

ASAP

Work Order ID 61121

Friday, August 06, 2010 2:19:05 PM



Page 1

Item ID: D4149-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Aft

Start Date: 8/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-8-06 Tooling:

Date:

Run

Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4149

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

Cut as per dwg D4149

Prog Rev: B

Dwg Rev: B

Deburr as required

BS 10-8-9

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

BS 10-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/09

10

150

Identify as per dwg & Stock Location: Russ

0.00



Packaging

Memo

0.00

Packaging

mf
10-8-9

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/09

01680 Aug -
mf 10-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, August 06, 2010 2:19:05 PM

Page 1

Work Order ID: 61121

Parent Item: D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 8/9/2010

Start Qty: 1.00

Required Date: 8/10/2010

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

90.4082

0.1355

0.142632



304/316 0.125 Sheet



B10-8-9

Location

Loc Qty

Loc Code

MAT

90.4082

114488

0.6359

114799

89.7723

114489

①

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 61121
Description: CROSSTUBE Lug PLATE. AFT		Part Number: 4149-1
Inspection Dwg: D4149-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

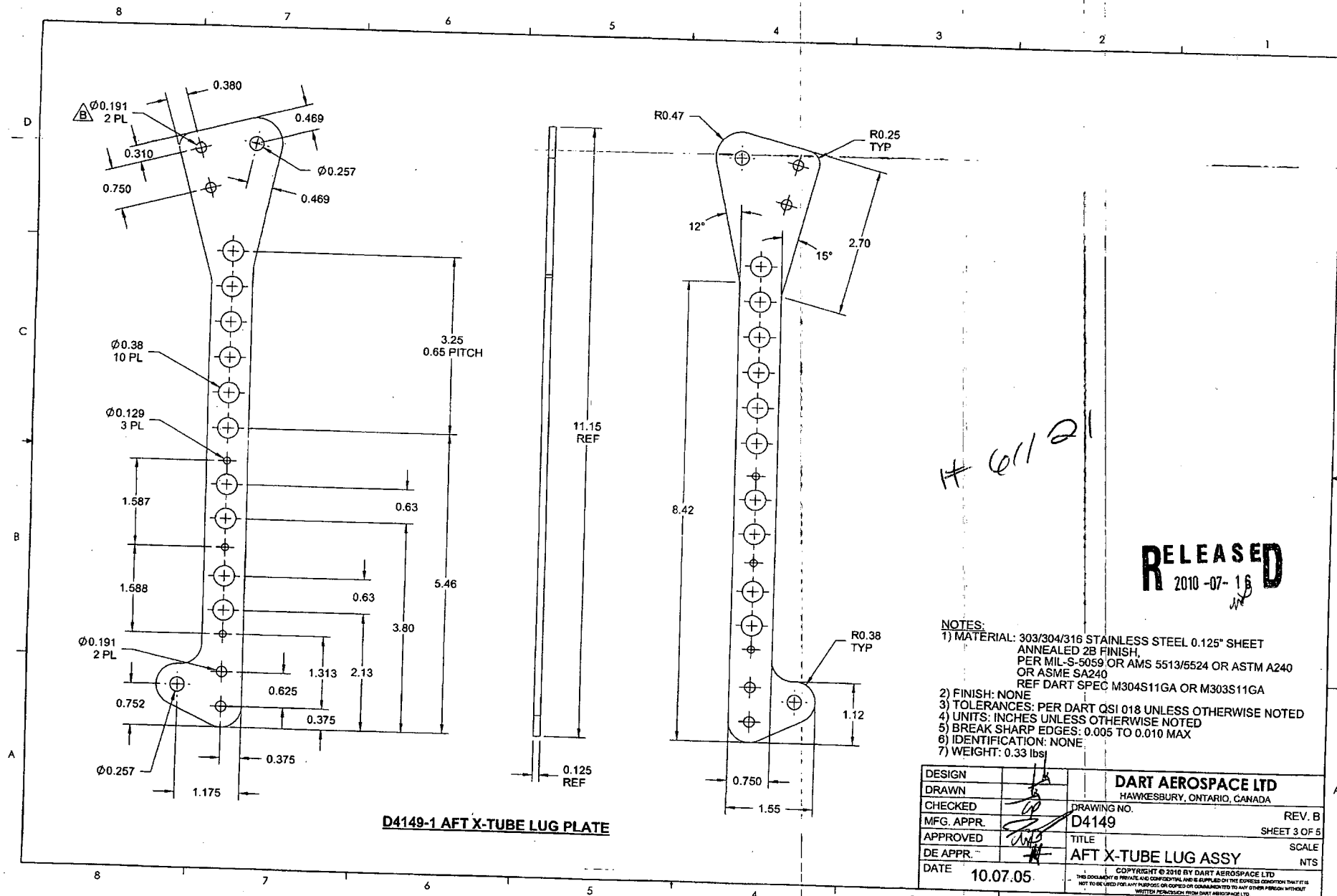
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	X		V HB 02	
Ø .191	+ .005 - .001	.192	X		V	
Ø .257	+ .006 - .001	.257	X		V	
Ø .38	+ .006 - .001	.379	X		V	
.310	TL .010	.311	X		V	
.386	TL .010	.380	X		V	
.750	TL .010	.750	X		V	
.469	TL .010	.471	X		V	
3.25	TL .030	3.250	X		V	
.65	TL .030	.653	X		V	
.63	TL .030	.624	X		V	
5.46	TL .030	5.460	X		V	
3.80	TL .030	3.801	X		V	
2.13	TL .030	2.131	X		V	
1.313	TL .010	1.313	X		V	
.375	TL .010	.373	X		V	
.625	TL .010	.625	X		V	
1.175	TL .010	1.173	X		V	
.752	TL .010	.754	X		V	
1.588	TL .010	1.589	X		V	
1.587	TL .010	1.587	X		V	
.750	TL .010	.760	X		V	
1.55	TL .030	1.555	X		V	
.125	TL .010	.119	X		V	

Measured by: AB
Date: 10-8-9

Audited by: S
Date: 10/08/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



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